

Applications

Mig Welding of dissimilar metals such as stainless steels and carbon steels

Characteristics on Usage

This wire contains a high ferrite level in its austenitic structure thus providing superior heat and corrosion resistance. SM-309MoL is suitable for the build up on low alloy or mild steel and welding of STS 316, 316L clad steel

Typical Chemical Composition of Wire (%)

C	Si	Mn	Cr	Ni	Mo
0.01	0.35	1.8	23.2	13.7	2.5

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)
660 (95,700)	34

Typical Welding Conditions (DC+)

Size mm(in)	A	V	Speed (cm/min.)	Gas Flow (ℓ /min.)	Remarks
1.2 (.045)	250	26	30	25	Shielding gas
1.6 (1/16)	300	29	35	25	100%Ar or Ar+2%O ₂